

WORK INSTRUCTION		
Title: <b>Replacement of IV/OC Lid Main O-Rings</b>		
Instruction No. <b>RH.02</b>	Rev. 0, July 2003	Page 1 of 2
Approved for Use by: <u>Michael R. Brown</u>		Effective Date: <u>July 2003</u>
Applicable Drawings:		
<ul style="list-style-type: none"> <li>• X-106-500-SNP (Sheets 1-9) RH-TRU 72-B Packaging SARP Drawings</li> </ul>		
SARP Requirements:		
<ul style="list-style-type: none"> <li>• Chapter 8.0, Section 8.2.4.3. O-rings shall be changed annually or when damaged.</li> </ul>		
Tools Required:		
<ul style="list-style-type: none"> <li>• Lead wire seal crimper</li> </ul>		
Spare Parts Required:		
<ul style="list-style-type: none"> <li>• The spare parts are identified in the work instruction steps. All spare parts listed are controlled and shall be recorded on the Maintenance Record.</li> </ul>		
Materials Required:		
<ul style="list-style-type: none"> <li>• Vacuum grease</li> <li>• Denatured alcohol or equivalent</li> <li>• Lint-free rags</li> <li>• Metal tags (leak test required) (PN 2077-02013 or equivalent)</li> <li>• Lead wire seals (PN 2077-02012 or equivalent)</li> </ul>		
Safety Requirements:		
<ul style="list-style-type: none"> <li>• Safety will be observed in accordance with site requirements.</li> </ul>		
Prerequisite Conditions:		
<ul style="list-style-type: none"> <li>• The O-ring to be replaced has been removed and discarded.</li> <li>• O-ring grooves have been inspected or repaired as necessary.</li> </ul>		
Instruction Steps:		
<ul style="list-style-type: none"> <li>• There is no requirement to replace components in the sequence shown here.</li> <li>• The spare parts listed below shall be replaced with like-for-like components from the approved spare parts supply.</li> <li>• The replacement of these parts shall be documented on the Maintenance Record.</li> <li>• This instruction <b>is not required to be attached</b> to the Maintenance Record, but may be used as a checklist during performance of maintenance.</li> </ul>		

**Containment O-rings**

☐ IV Lid Middle Main O-ring ..... (PN 2078-200-06) PO#\_\_\_\_\_

☐ OC Lid Inner Main O-ring ..... (PN 2078-300-03) PO#\_\_\_\_\_

- 1.0 Thoroughly clean the O-ring grooves using alcohol and lint-free rags.
- 2.0 Lightly coat the O-ring with vacuum grease. One teaspoon of grease is sufficient to coat the O-ring.
- 3.0 Install the lubricated O-ring into the groove, ensuring it is seated around the entire circumference of the groove.
- 4.0 If shipping radioactive waste, perform a Pre-shipment (Helium) Leakage Rate Test, and attach documentation to the Maintenance Record.
- 5.0 If shipping an empty container, wire/crimp a "Leak Test Required" tag to the outer cask pad eye with the name of the replaced O-ring written in indelible ink on the reverse side of the tag, and annotate on the Maintenance Record that the tag was attached.

**Non-containment O-rings**

☐ IV Lid Inner Main O-ring ..... (PN 2078-200-05) PO#\_\_\_\_\_

☐ IV Lid Outer Main O-ring ..... (PN 2078-200-07) PO#\_\_\_\_\_

☐ OC Lid Outer Main O-ring ..... (PN 2078-300-04) PO#\_\_\_\_\_

- 1.0 Thoroughly clean the O-ring grooves using alcohol and lint-free rags.
- 2.0 **LIGHTLY** coat the O-ring with vacuum grease. One teaspoon of grease is sufficient to coat the O-ring.
- 3.0 Install the lubricated O-ring into the groove, ensuring it is seated around the entire circumference of the groove.

**Verification Requirements:**

- 1.0 Spare parts used are listed on the Maintenance Record.
- 2.0 Helium leak test documentation is attached to the Maintenance Record.
- 3.0 If the helium leak test has been deferred, a "Leak Test Required" tag is attached to the packaging and is annotated on the Maintenance Record.
- 4.0 Work performed is listed on the Maintenance Record.
- 5.0 Work Instruction is listed on the Maintenance Record.